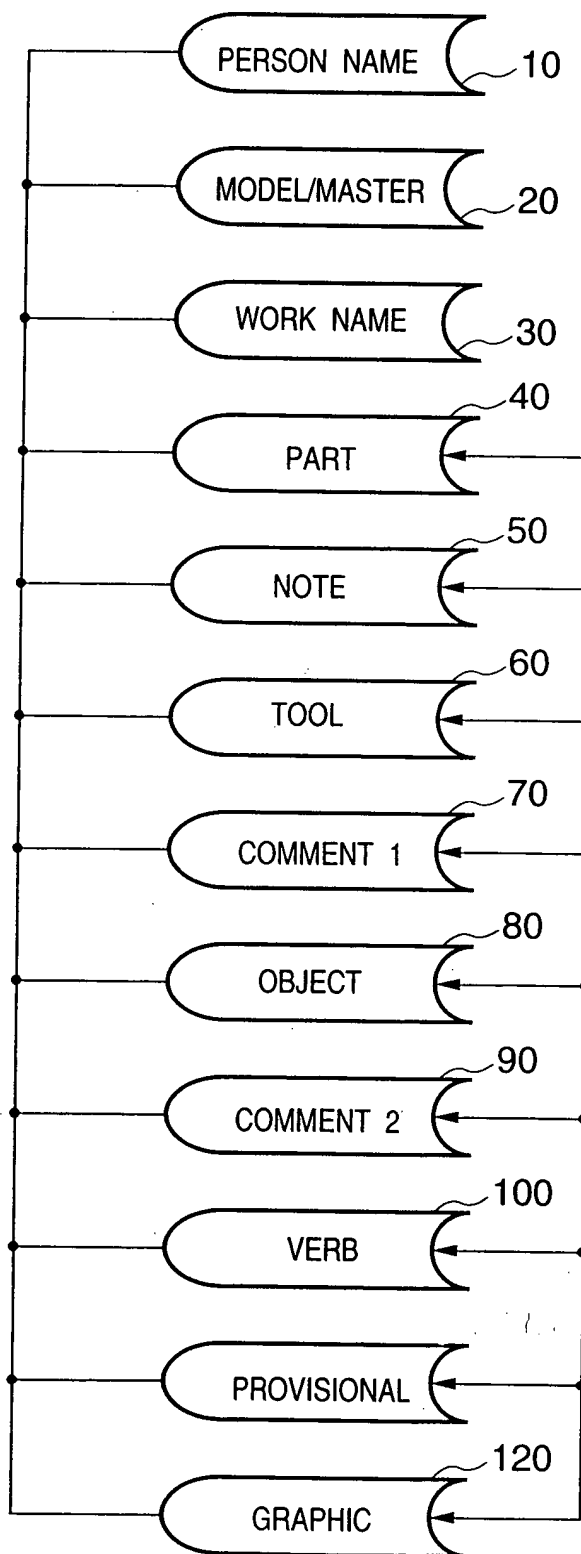


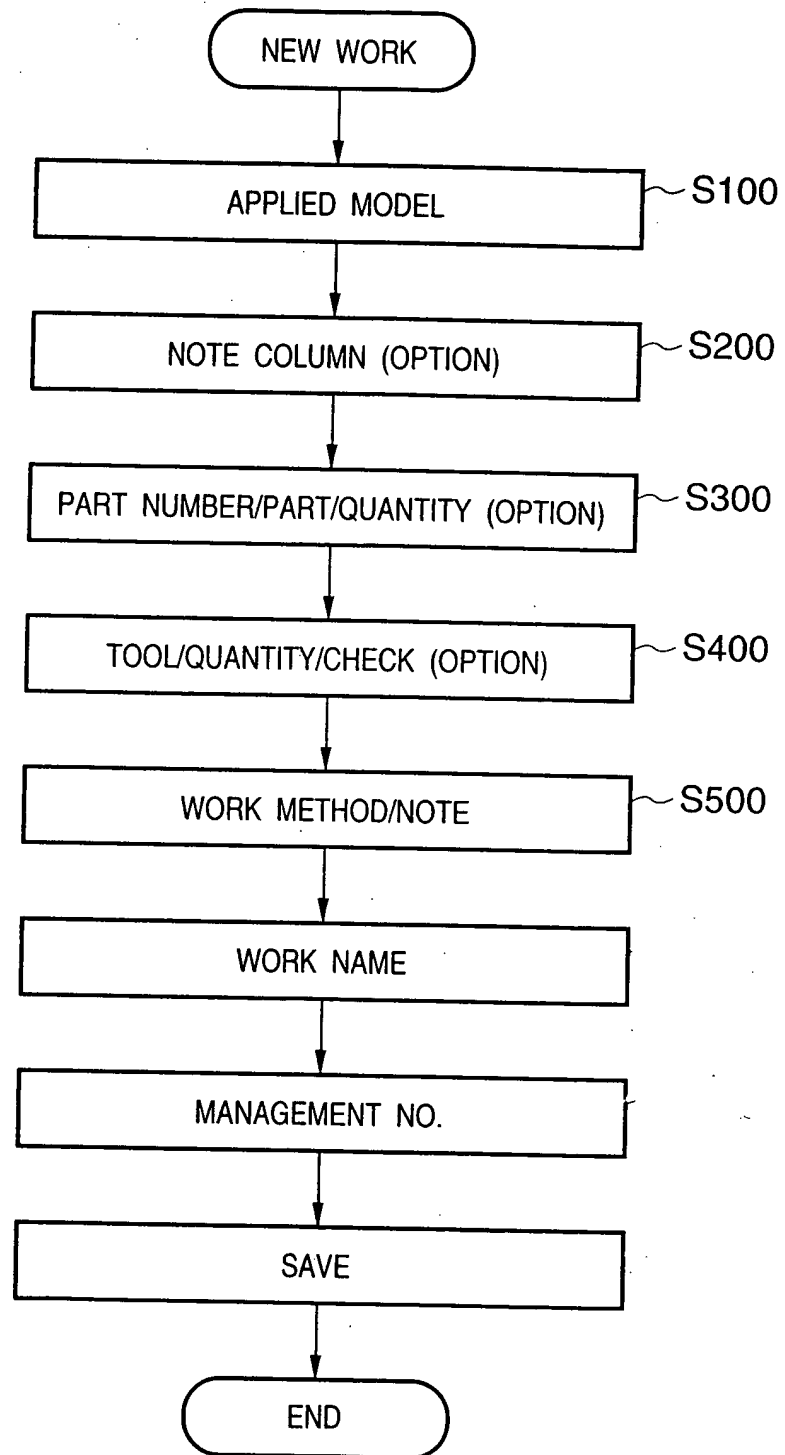
FIG. 4

STRUCTURE OF MASTER FILE



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FIG. 5



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FIG. 23

WORK STANDARD SYSTEM			
<input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL			
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	SET ASFu	1997/09/13
SO-01-01(3)-E	01	SET BASE TRAY	1997/09/01
SO-01-03-E	01	SET BASE TRAY	1997/09/01
SO-01-04-E	01	SET BASE TRAY	1997/09/01
SO-06-01-E	01	WIRING	1997/09/01
SO-06-02-E	01	WIRING	1997/09/01
SO-06-03-E	01	WIRING	1997/09/01
SO-07-01(2)-E	01	GREASING	1997/09/01
SO-08-01-E	01	SET RAIL	1997/09/01

2301

FIG. 25

WORK STANDARD 01 CREATION

APPLIED

PART NUMBER

303

PART NAME

TOOL / TREATMENT DEVICE

WORK PROCEDURE

FILE NAME :

2501

UPDATE

CLEAR

CLOSE

REVISION NUMBER

01

CONTENTS OF REVISION

CREATED

DATE

1997/09/25

PERSON IN CHARGE

APPROVE

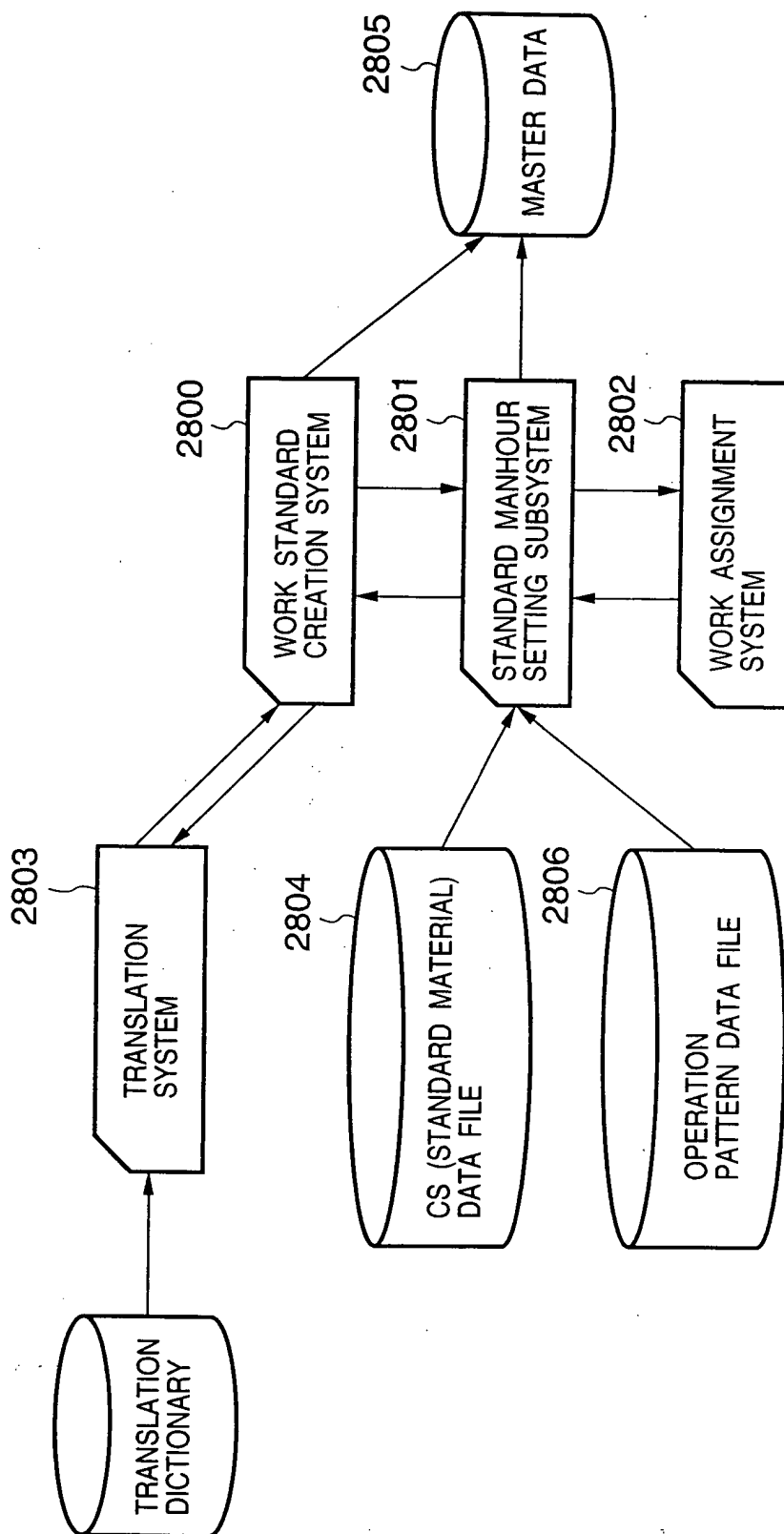
WORK NAME

MANAGEMENT NO.

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FIG. 28



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FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☐ ASSEMBLY
☒ UNIT
☐ ASSEMBLY

DISPLAY DATA

☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE

☐ JAPANESE
☒ ENGLISH

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION CHECK
PT-010-010	01	SET CLEANER UP	X
PT-010-020	01	SET CLEANER UP	X
PT-010-030	01	SET CLEANER UP	X
PT-070-030	01	ASSEMBLE CHANGEOVER ARM	X
PT-080-010	01	SET TRANSMISSION ROLLER	X
PT-090-010	01	SET TRANSMISSION ROLLER	X
PT-100-010	01	SET SHEET HOLDER	X

3006 3007 3008 3005

FIG. 31

[illegible]

FIG. 47

[illegible]

REPLACEMENT SHEET

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FIG. 55

SELECTION OF MODEL									
FILE(E) EDIT(E) VIEW(V)									
<div> </div>									
PRODUCT SYMBOL : BJ - 970909 NAME : 097 - 09 - 09 LOAD SET MODEL SYMBOL : BJC - 4300 COMPONENT SYMBOL : ON NAME : NAME : xxxxxx LATEST REVISION NUMBER UPDATE DISPLAY									
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY		
N _i 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	0	1	
N _i 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	0	1	
N _i 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	0	1	
N _i 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	0	1	
N _i 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	0	1	
N _i 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	0	1	
N _i 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	0	1	
N _i 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	0	1	
N _i 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	0	1	
No. FORMAL MANAGEMENT NO. UNIT WORK NAME MANHOUR USE FREQUENCY 1 2 3 4 5									
3	CH-01-01	ELECTRICAL CHECK		0	0	0	0	1	
<div> <input type="radio"/> CHANGE <input type="radio"/> INSERT <input type="radio"/> ADD </div> <div>OK</div>									
5501 5507 5506 5502 5503 5504 5505									

REPLACEMENT SHEET

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FIG. 56

XXXXXX

5606

FORMAL MANAGEMENT NO. PU-03-01 UNIT WORK NAME: MOTOR ATTACHMENT TOTAL MANHOUR: 0 NEXT UNIT WORK

NO.	ELEMENT WORK NAME.	REVISION	MANHOUR	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						

COMMENT 1 : TO OPPOSITE SIDE OF AXIS

OBJECT : DOUBLE GEAR

COMMENT 2 : IN ORDER OF SMALL GEAR DIAMETER

VERB : SET

5604 5605 5603 5602 5601

REPLACEMENT SHEET

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FIG. 57

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE/COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR/USE/FREQ.	COUNT	SET DATE	
▶	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/Gr1/N/>6/-3	15	0 1 1 0	97/09/09 9:52
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/E/02/N/-6	11	0 1 1 0	97/09/09 9:53
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/Gr1/N/>6/-3	15	0 1 1 0	97/09/09 9:55
		ELEMENT WORK 01		VERB	-50/Gr1/N/>6/-3	15	0 1 1 0	
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/Gr1/N/>6/-3	15	0 1 1 0	97/09/09 16:34
		CARRIAGE LOCK		APPLY	Time100/Rate100	100	100 1 1 1	97/09/09 19:09
	ASSEMBLE MOTOR	PRINTER CHASSIS	INSERT & SET	M211/1/10	50	1 1 1 1	1	97/09/09 19:16
		PRINTER CHASSIS		TURN INSIDE OUT	T1221/M2311/0/0	12	0 1 1 0	97/09/09 17:34
	1		1	T2221/M1211/0/1	24	0 1 1 0	0	97/09/09 17:20
	2		2	T1221/M2311/0/0	12	0 1 1 0	0	97/09/09 17:24
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1 0	0	97/09/09 11:24
	dgdffdfas		fdasfdasfasad	*	16	0 1 1 0	0	97/09/09 12:10
	dsdsffsfdsaf		fdasfdsdffds	T2121/M1111/0/1	13	0 1 1 0	0	97/09/09 12:10
	dgdffdfas		fdasfdasfasad	*	16	0 1 1 0	0	97/09/09 13:39
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1 0	0	97/09/09 14:00
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1 0	0	97/09/09 14:00
	PRINTER UNIT		SET	Time100/Rate100	100	100 1 1 1	0	97/09/09 14:04

FIG. 58








OPERATION ANALYSIS		5801		5802		5803		5804	
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> <div style="border: 1px solid black; padding: 2px; text-align: center;">  </div> </div>									
1 SET MAIN BODY TO PREDETERMINED POSITION		TOTAL SIMO VALUE : 0		TOTAL MANHOUR VALUE: 15		SIMO		NEXT ELEMENT WORK	
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOUR	USE	REMARKS			
▲ 1	XXXXXX	PU	-60/Gr1/N/>6/-3	15	0				
*									

FIG. 62

The figure shows a rectangular window titled "INQUIRY OF LOG". Inside the window, there are four labeled input fields and two buttons at the bottom. Reference numerals are used to identify specific parts of the interface:

- 6201** points to the title bar of the window.
- 6202** points to the "VARIATION AMOUNT" input field, which contains the value "10".
- 6203** points to the "USE" input field, which contains the value "0".
- 6204** points to the "REASON CODE" input field, which contains the value "1".
- 6205** points to the "CHANGE REASON" dropdown menu, which currently shows "SET" and has a downward arrow icon.
- 6206** points to the "OK" button.

The "Clear" button is also present at the bottom right of the window.

REPLACEMENT SHEET

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FIG. 72

FILE(F) EDIT(E)

PLAN 1

COMPOSITION EFFICIENCY %

FILE(F) EDIT(E)

PLAN 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

OK

CANCEL

REPLACEMENT SHEET

73/97

FIG. 73

FILE(F) EDIT(E)

PLAN 2

COMPOSITION EFFICIENCY %

FILE(F) EDIT(E)

PLAN 2

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0008	XXXX	270

St 2

0003	WEIMAN REMOVAL	365
0004	ASSEMBLE OUTER CASE	268
0005	FIT TOP PAD	117

DRAG AND DROP

OK

CANCEL

REPLACEMENT SHEET

76/97

FIG. 76

7601 7602 7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

f12-0010.csv	1	97/09/19 12:00:34
f12-0010.csv	0	97/09/19 13:27:17
BJC-4300	0	97/09/19 14:10:14
BJC-4300	0	97/09/19 14:10:32
BJC-4300	1	97/09/19 15:41:14
BJC-4300		97/09/20 14:16:38
BJC-4300	03	97/10/13 17:54:57
BJC-4300	00	97/09/20 14:06:36
f12-0010.csv	05	97/09/24 17:11:53

TEST DATA (ORIGINAL)

TEST

0

0

0

0

1

BJC-4300A LINE FORMATION

BJC-4300A LINE FORMATION

BJC-4300A LINE FORMATION

f12-0010A LINE FORMATION

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

FIG. 77

[illegible]

REPLACEMENT SHEET

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FIG. 80

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1 OPERATOR 2 OPERATOR 3 OPERATOR 4 OPERATOR 5

S11 S12 S13 S14 S15

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT NAMEa1	5/9	0	9000
UNIT NAMEa2	54	0	9000
UNIT NAMEa3	10	0	9000
UNIT NAMEa4	50	0	9000

CLEAR(V)

xxxx
xxxx
xxxx
xxxx
DELETE STATION
xxxx

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT NAMEu1	63	0	9000
UNIT NAMEu2	30	0	9000
UNIT NAMEu3	156	0	9000
UNIT NAMEu4	35	0	9000

0001 xxx LOCK 201
0002 MIRROR SPRING 236
0003 xxx LOCK 285
0002 MIRROR SPRING 525
ATTACHMENT

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT NAMEu9	144	0	9000
UNIT NAMEu10	16	0	9000
UNIT NAMEu11	293	0	9000
UNIT NAMEu12	133	0	9000

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT NAMEu13	33	0	9000
UNIT NAMEu14	72	0	9000
UNIT NAMEu15	35	0	9000
UNIT NAMEu16	56	0	9000
UNIT NAMEu17	150	0	9000
UNIT NAMEu18	16	0	9000
UNIT NAMEu19	250	0	9000

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT NAMEu20	250	0	9000
UNIT NAMEu21	0	0	9000
UNIT NAMEu22	50	0	9000
UNIT NAMEu23	55	0	9000
UNIT NAMEu24	88	0	9000
UNIT NAMEu25	147	0	9000
UNIT NAMEu26	52	0	9000
UNIT NAMEu27	55	0	9000

TOTAL 693 (RU) PF 105.0% TOTAL 609 (RU) PF 92.3% TOTAL 566 (RU) PF 86.8% TOTAL 596 (RU) PF 90.3% TOTAL 565 (RU) PF 85.8%

8009 8008 8004 8006

G STANDARD NO. WORK NAME UNIT NAMEa1

MA-CHINE MAN-CHINE MAN-CHINE

PROVISIONAL MAN-CHINE MAN-CHINE

REMARKS

COMPOSITION EFFICIENCY 94.92 %

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE: PRIORITY ORDER SCHEME

REPLACEMENT SHEET

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FIG. 84

PARALLEL OPERATION / INTEGRATION OF STATIONS

TARGET STATION : 1

THE NUMBER OF STATIONS

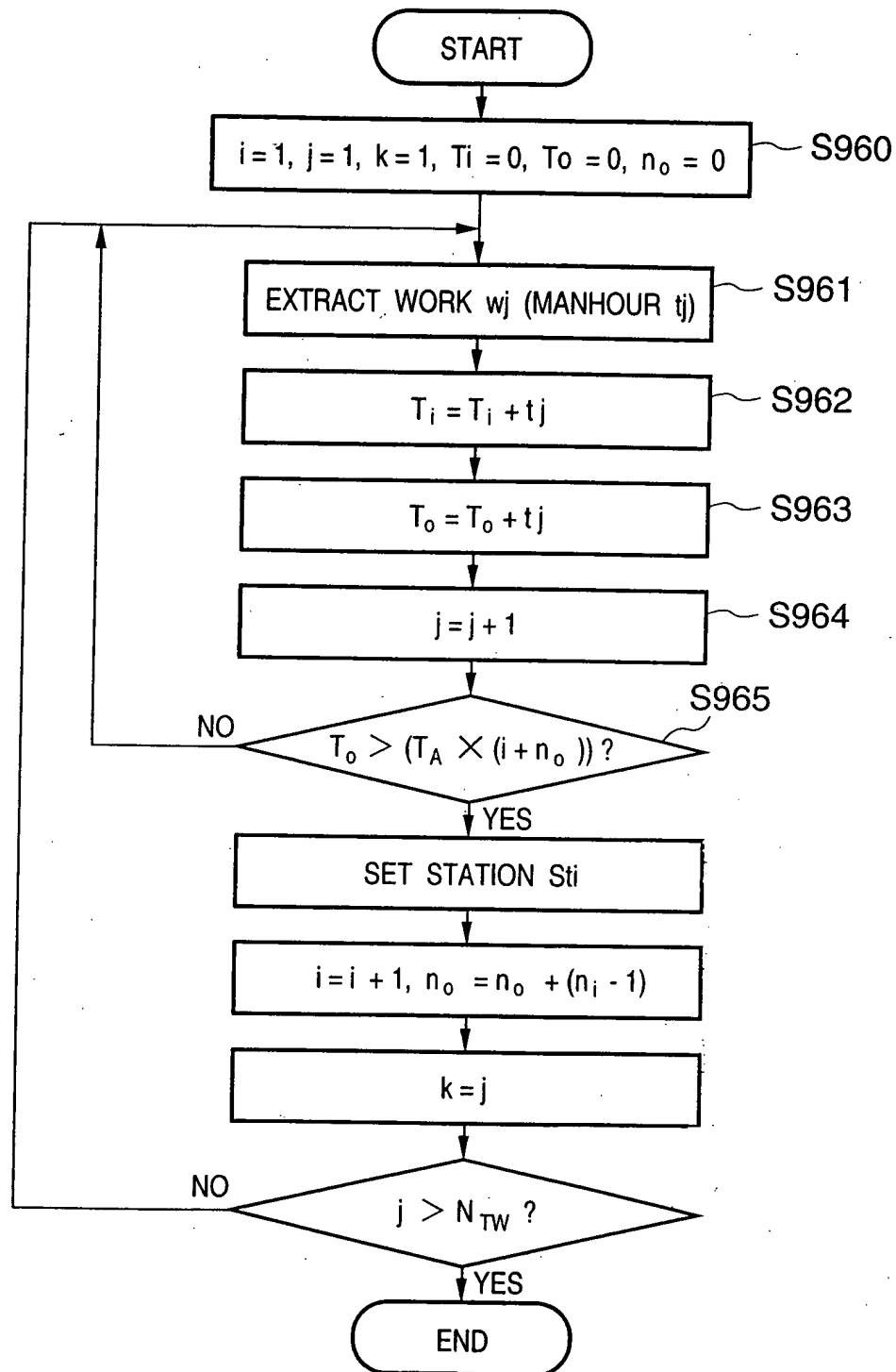
OK CANCEL

8402

REPLACEMENT SHEET

96/97

FIG. 96

 N_{ST} : THE NUMBER OF STATIONS T_i : i STATION MANHOUR T_A : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

 T_o : TOTAL ACCUMULATED MANHOUR n_i : i STATION PARALLEL NUMBER n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

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